

Date: Thursday, 11/12/2008 10:45:04 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB ASSY (BASKET LID, RH)
Job Number : 44021	
Estimate Number : 13664	
P.O. Number :	Part Number : D3838042
This Issue : 11/12/2008 S.O. No. :	Drawing Number : D3838 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run :	Material :
Written By :	Due Date : 22/12/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 08.12.11</u>	
Comment : Est Rev:A 08-12-01 new issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D37591	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

batch: 2B44059

SY 09/01/06

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 1.0833 f(s)/Unit Total : 4.3331 f(s)

304 SQ Tube .75x.75x.065W

batch: M110011

SAD 08-12-29

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- drill hole in D3838-2 as per dwg D3836 using DT9437 jig

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

SAD 08-12-29
SAD 08-12-29
SAD 08-12-29
SAD 08-12-29
SAD 08-12-29

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08-12-30
(4)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- weld D3759-1 bushing as per dwg D3838

2- grind bushing weld flush as per dwg dwg D3838

SY 09/01/06
SP 09.01.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:45:04 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, RH)

Job Number: 44021

Part Number: D3838042

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- deburr hole if necessary

4- weld D3838-2 to D3838-3 as per dwg D3838 using DT9447 welding jig

****after welding ensure measurements are good****

A/R ER316 S.S. Rod Batch: M 166762

5- grind weld flush where indicated on dwg D3838

SP 09-01-05

dy 09/01/06

6.0

QC9

VISUAL WELDING INSPECTION



CP 09-01-06



Comment: VISUAL WELDING INSPECTION

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/06 (40)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BASKET CELL

dy 09/01/07 (4x)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

4
D 09/01/08

Job Completion



mk 09-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

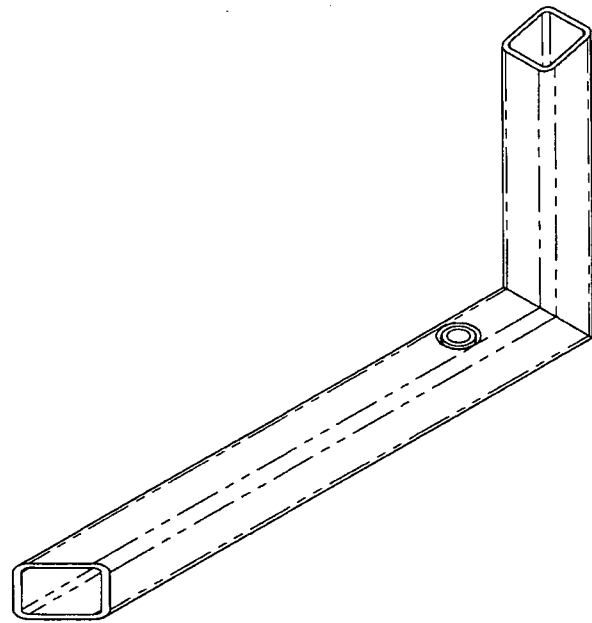
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

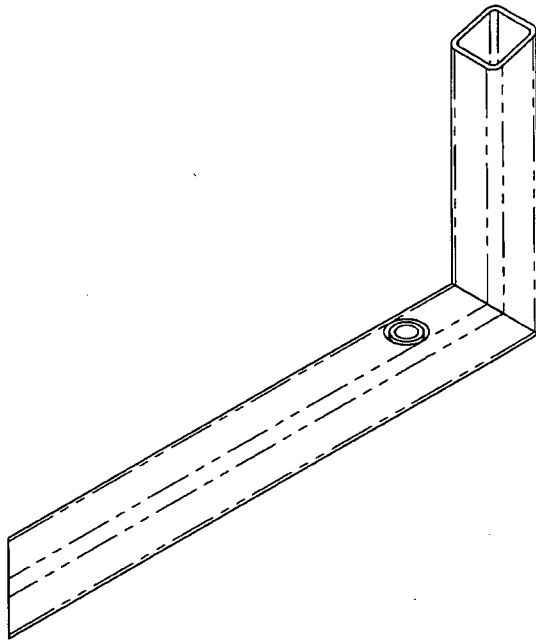
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



D3838-041 RIB ASSY (BASKET LID, LH)



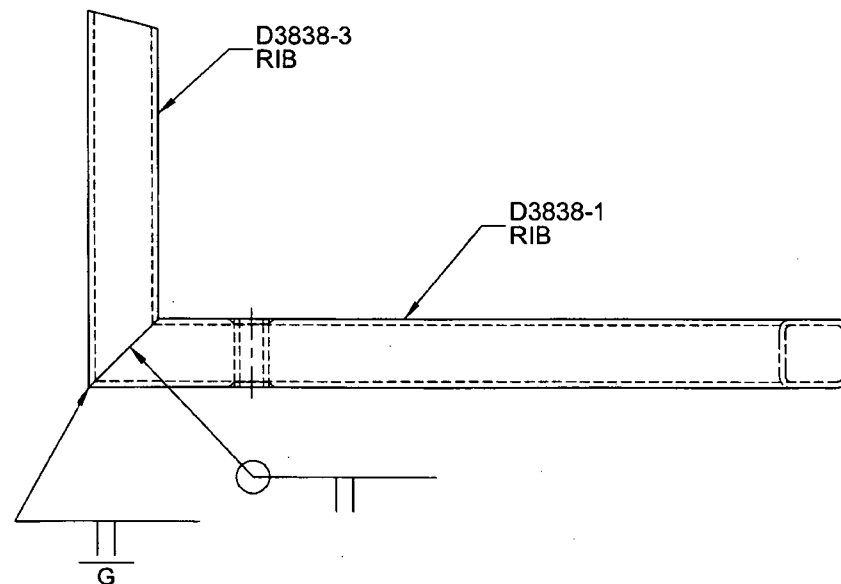
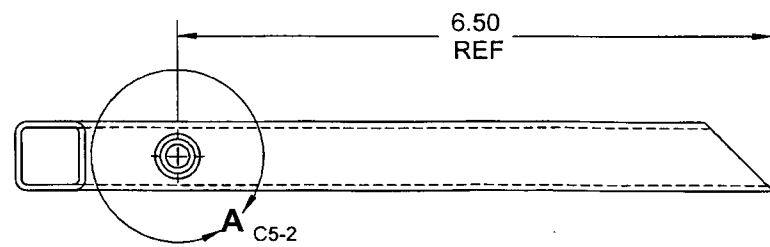
D3838-042 RIB ASSY (BASKET LID, RH)

NOTES:

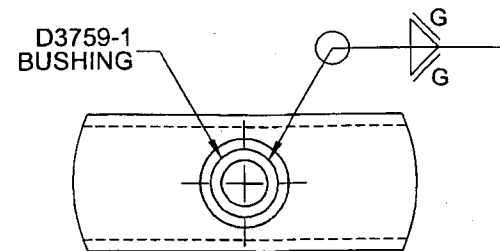
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

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WITHOUT NOTICE
WORK ORDER
NO. 44021

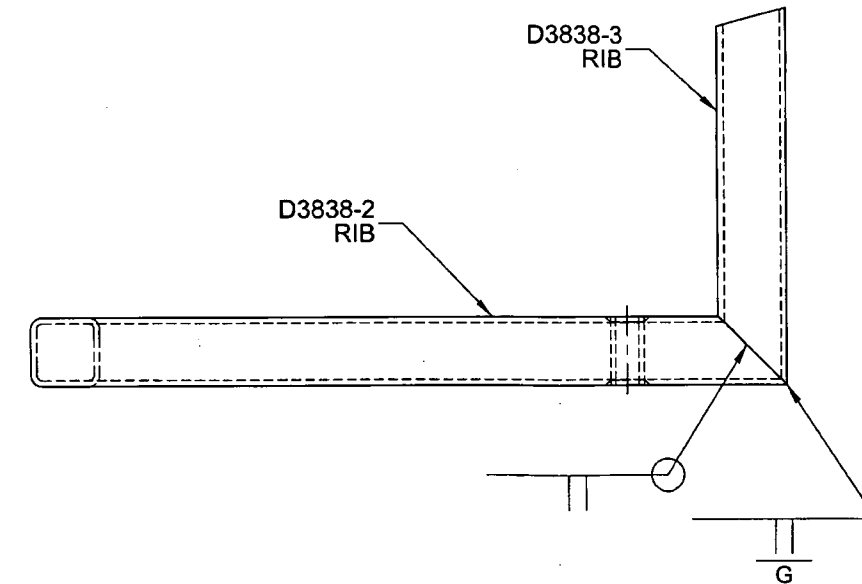
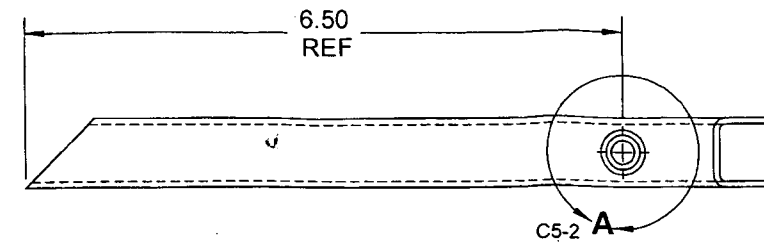
A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. A
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DE APPR.		RIB ASSY (BASKET LID)	NTS
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D3838-041 RIB ASSY (BASKET LID, LH)



DETAIL A
D2-2 SCALE 2X
D7-2



D3838-042 RIB ASSY (BASKET LID, LH)

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08/11/18 NW

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NO. 44051

A

A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL
REF. DART SPEC. M304TS0.750V
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS
- 4) UNITS: INCHES UNLESS OTHERWISE NOTE
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1-2 = 0.35 lbs EACH; D3836-3

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3838

REV. A

SHEET 3 OF 3

TITLE

RIB ASSY (BASKET LID)

SCALE

NTS

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